

Date: Thursday, 04/06/2009 7:12:53 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GAS SPRING ASSEMBLY
Job Number :	48373		
Estimate Number :	10181		
P.O. Number :		Part Number :	D2153
This Issue :	04/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2153 REV. A1
First Issue :	//	Project Number :	N/A
Previous Run :	45058	Drawing Revision :	A1
	Type :	Material :	
	PURCHASED PARTS	Due Date :	11/06/2009
Written By :		Qty:	36 Um: Each
Checked & Approved By :	C209/06/04		
Comment :	Est: E 02.07.08 Re-format KJ/RE		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8914

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

C209/06/04

(36)

2.0	D2153P	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 GAS SPRING ASSEMBLY

36

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P 9/6/17 (36)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

S09/06/18

counters

(x36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 48373

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Locknut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

B48238

Ep09/06/22

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

M111279

Ep09/06/22

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

M1109239 (6x)

M110685 (74x)

Ep09/06/22

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

Ep09/06/22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep09/06/22 (36)
count
8 07/06/22 (+36)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57272

Pc 4/4/22 (36)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/06/2009 7:12:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 48373

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-06-23

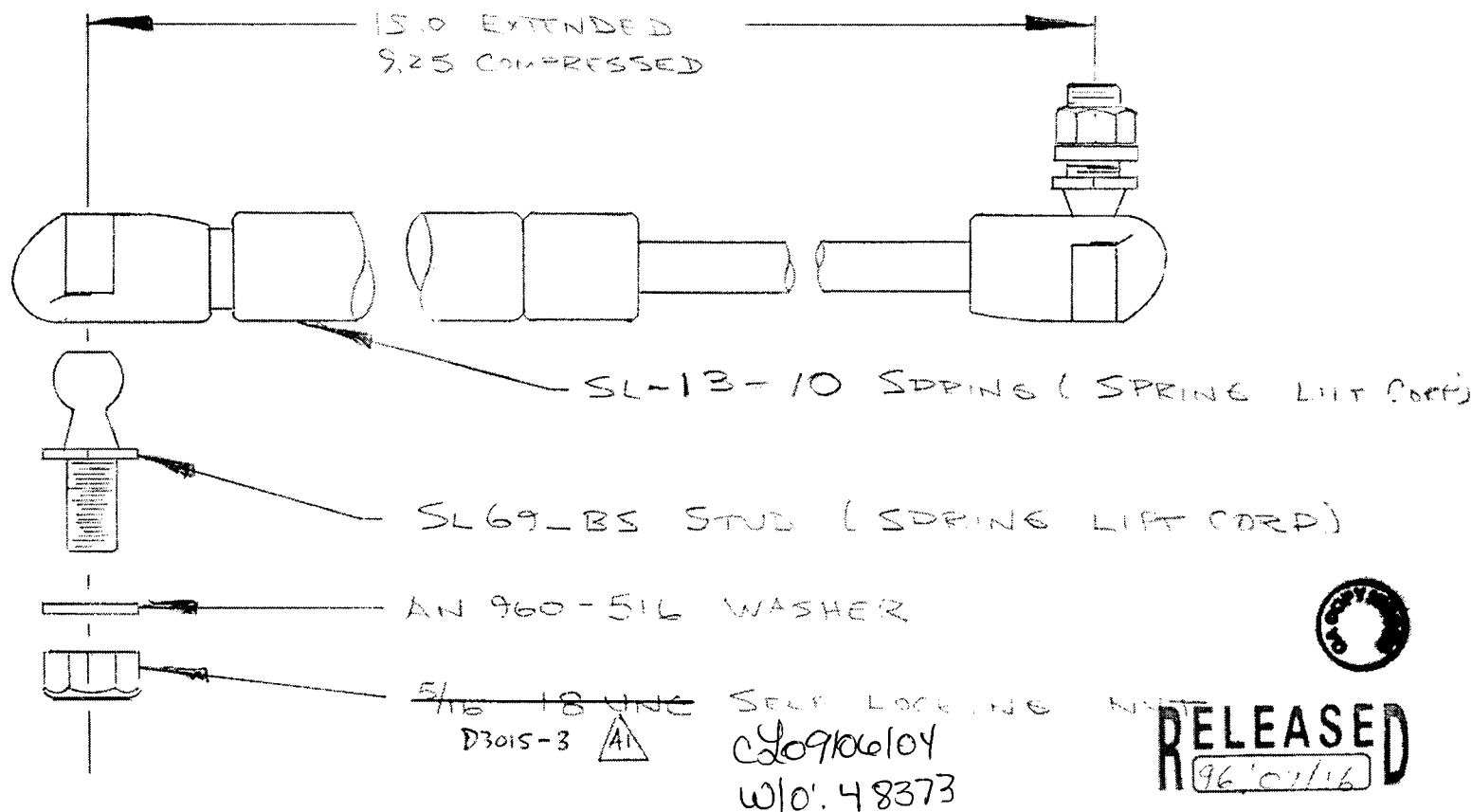
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



A1 CHANGE TO D3015-3 SL 13-10 WAS 2632-15		REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE D-DIMPLE DRIFT-HD OF SHEET C-COUNTERSINK LENGTH DASH NO W-SPOTWELD BASIC CODES B-M520470AD BB-M520476AD	PART NO. CONTRACT NO. DRAWN HATTON DATE 2/28/72 DESIGN HATTON/ STRESS CHECKED L. J. J. 2/28/72 CLIENT	ITEM DESCRIPTION DART DART AERO ACCESSORIES INC. VANCOUVER CANADA TITLE GAS SPRING ASSEMBLY CODE D2153 SCALE 1:1 SHEET 1 OF 1	MATERIAL SPEC. VENDOR REV A
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 8 — 7742 5. HOLES PER AND 10387			LIMITS 1. TOLERANCES — SEE 2.030 2. ANGLES 1 1/2° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRAL LINES .005				
REPORT ALL DISCREPANCIES — DO NOT SCALE							

atwood®



COST: 68580 MST: 61171

TELEPHONE: 616-897-2290

COLLECT 5645W

BILLTO: DART AERO LTD.
REQ#06/12/09

PRO NO: 442 40717
SHIP VIA: UPS GROUND
BOL: 002269700015824

FATTWOOD / SWIVL-EZE

FREIGHT: _____

1016 NORTH MONROE
LOWELL MI 49331-0260

DART AERO LTD.
1270 ABERDEEN STREET

HAWKESBURY ON K6A 1K7

CRTS: 1 X PO#: 00008914

WGT: 15 DATE: 06/11/09

SPUR

LA BEL MFG
4936010011

---ROUTING GUIDE INFO---

---SHIPPED---

QTY	LOCATN	UM	PART#	UFC	DESCRIPTION	SKU	LINE	QTY	ORDER
1	36	Z09211	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	2	3	10	
1	100	Z10321	EA	SL69-B5-1	10MM BALL STUD W/THRD	10	10		

Soluble